

Date: Thursday, 29/05/2008 11:04:35 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	6" MIRROR
Job Number :	39555		
Estimate Number :	10101		
P.O. Number :		Part Number :	D2011101
This Issue :	29/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2011 REV. F
First Issue :	/ /	Project Number :	N/A
Previous Run :	38288	Drawing Revision :	F
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.5.29</u>	Due Date :	10/06/2008
Comment :	Est: J 04.09.15 Added Steps 5-7 Est: K 05.12.15 chg black sikaflex for white	Qty:	50 Um: Each
			48

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 6465

Purchase Grote Mirror P/N: 28043

Possible supplier: UAP/NAPA

Material release note required

CJ08/05/30

(50)

2.0

28043

MIRROR 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

PC 8/6/3 (50)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

S 08/06/05 counts

5.0

D30141

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Locknut

Pick:

Qty Part Number Description Batch

1 D3014-1

Lock nut

B25021

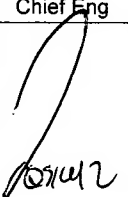
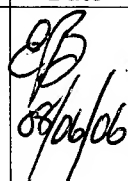

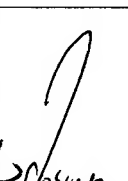

08/06/05

(P2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2011-101 PAR #: N/A Fault Category: Prod / P/B not to SM All NCR: Yes No DQA: D Date: 08/04/07
 QA: N/C Closed: D Date: 21/06/10

NCR: <u>39555</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/05	5.0	#. two mirrors broke when the Drive Bit. Broke. P.C Drill Bits Broken		Scrap and Destroy no Replace	 08/06/06	 08/06/06		 08/06/06

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:04:35 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 39555

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

1107008

08/06/05

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch
9ml N/A Sikaflex-291/-241

1107804

Expiry date

10/2008

Start: 08/06/05 Time: 8h20

Finish: 08/06/05 Time: 1400

08/06/05

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

08/06/06 (48)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 227

8/6/6

(48)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/06

Job Completion



08.06.06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

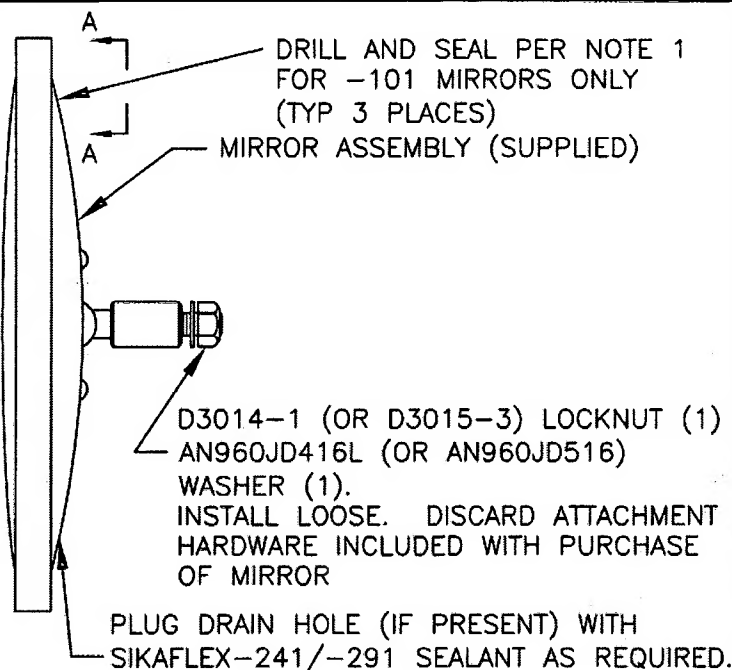
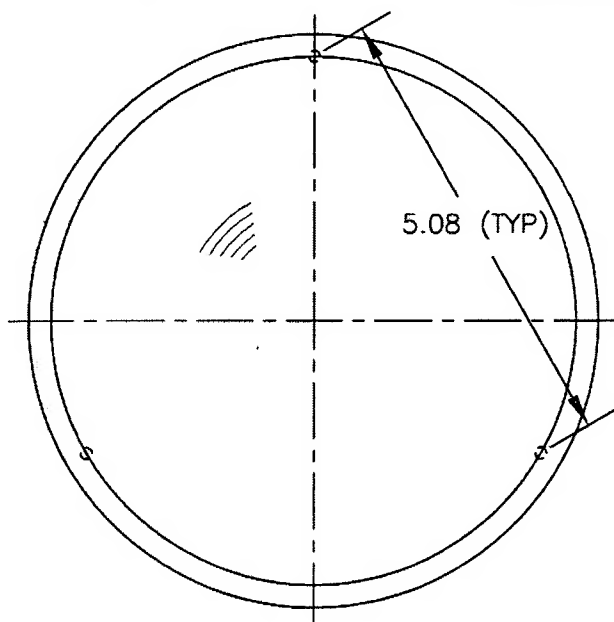
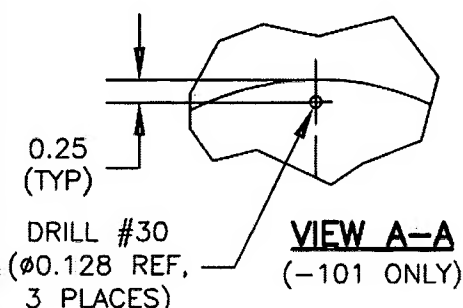
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

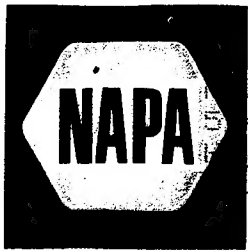
- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39553

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RELEASED
04.09.10



WILKESBURY AUTO PARTS INC 5580BST#:

86159789ERT0001

554 MAIN STREET WEST

WILKESBURY, ONT. K6A 2J2

TEL: 632-8575 FAX: 632-1539

DANGEROUS GOODS PERMIT
EXPIRY DATE:EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT # SOLD TO DATE TIME STORE # EMP # INVOICE NO.

SR #	AD	3501 AEROSPACE LTD 1270 ABERDEEN STREET WILKESBURY, ONTARIO K6A 2J2	6/03/08 14:24 060004074 81 202050	PURCHASE ORDER #	ATTENTION
			00005465	TAX EXEMPTION: 5122-5297	
			TERMS: NET 30 DAYS CHARGE SALE		
			DELIVERY:		

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
✓	002	BROVE	30.00	33.470	16.820	241.00 7157
<i>S. Durand</i>						
<i>EN PASSANT</i>						

Subtotal	241.00
Tax 5% GST ONLY	12.05
Tax 0%	0.00

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL -----> CHARGE SALE 263.05

DART

Purchase Order

Date May 30, 2008	Page 1
Purchase Order Number PO00006465	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
686930

Vendor Address:

Uap Hawkesbury Inc. #074
514 Main Street West
Hawkesbury, ON K6A 2J2
Phone (613) 632-8575
Fax (613) 632-1539

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-UAP001	May 30, 2008	N30	yours	Jun 06, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
50.0000	28043	MIRROR 6" Comments: AS PER DWG D2011 REV. F P/N: 28043 B39555	6/6/2008	No	16.820000	Each	841.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:**Tax Summary:**

GST 42.05
GSTME 0.00
GSTND 0.00

Less:
included tax

0.00

Subtotal

841.00

Total tax

42.05

Total purchase order in

CAD Dollars

883.05

Entered By: *CL* CLAVOIE

Approved By: *[Signature]*